

Fire Red

Dart Aerospace Ltd.

Date: Tuesday, 21/04/2009 4:01:05 PM  
User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PEDAL LOCK COVER  
Job Number : 47343  
Estimate Number : 10445  
P.O. Number :  
This Issue : 21/04/2009 S.O. No. :  
Prsht Rev. : NC Part Number : D33683  
First Issue : / / Type : MACHINED PARTS Drawing Number : D3368 REV B  
Previous Run : 45790 Project Number : N/A  
Drawing Revision : B  
Material :  
Due Date : 10/05/2009 Qty: 6 Um: Each  
Written By :  
Checked & Approved By : 0009.04.21  
Comment : Est. A 05.01.27 New issue KJ/JLM  
Est Rev:B 08-07-15 add QC3 DD verified by:ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2000X02000 6061-T6 Bar 2.00 x 2.00



Comment: Qty.: 0.9277 f(s)/Unit Total: 5.5661 f(s)  
Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)  
(M6061T6B2.000x02.000)  
Batch: M110936 X5 M16724X1 09/04/25 (6)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Machine D3368-3 as per Folio FA500 and Dwg D3368  
Identify as D3368-3  
Deburr HA 09/04/25 (6) NCR

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE HA 09/04/25 (6)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK SP 09/04/28 (6)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1







Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1 HA 09/04/29 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 09/05/06

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/25	2.0	Drilled the tapped hole wrong side (operator error) (1 part)		Fill with weld & grind flush	<del>H.A.</del> <del>PD</del> 09/04/25 	PD 09-04-28		 09.04.28

NOTE: Date & initial all entries

Date: Tuesday, 21/04/2009 4:01:05 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK COVER

Job Number: 47343

Part Number: D33683

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m102391



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

~~15:55~~ 9:00

OVEN TEMPERATURE:

~~320~~ 3:20

FINISH TIME:

9:30

cmd FL

09/05/01

(16)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-01

(16)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST480

SS 09/05/04 (16)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04 (16)

Job Completion



MF 09-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 127343
<b>Description:</b> Pedal Lock Cover		<b>Part Number:</b> D3368-3
<b>Inspection Dwg:</b> D3368	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

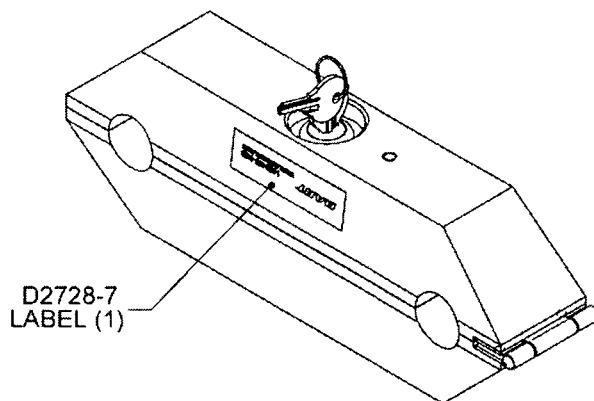
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/-0.030	10.250	✓			
7.250	+/-0.010	7.250	✓			
0.650	+/-0.010	0.650	✓			
0.107	+/-0.010	0.107	✓			
1.800	+/-0.010	1.797	✓			
45°	+/-0.5°	45°	✓			
Ø1.300	+/-0.010	Ø1.299	✓			
Ø1.400	+/-0.010	Ø1.400	✓			
Ø1.031	+/-0.010	Ø1.031	✓			
0.250	+/-0.010	0.250	✓			
1.500	+/-0.010	1.500	✓			
1.440	+/-0.010	1.439	✓			
2.00	+/-0.030	2.00	✓			
7°	+/-0.5°	7°	✓			
0.635	+0.010/-0.000	0.638	✓			
Ø1.250	+/-0.005	Ø1.246	✓			
0.250 deep	+/-0.010	0.250	✓			
1.000	+/-0.010	1.000	✓			
1.450	+/-0.010	1.449	✓			
0.375	+/-0.010	0.375	✓			
0.310	+/-0.010	0.310	✓			
Ø0.750	+0.010/-0.000	Ø0.752	✓			
Ø0.185	+0.005/-0.000	Ø0.189	✓			

<b>Measured by:</b> H.A	<b>Audited by:</b> SF	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/04/25	<b>Date:</b> 09/04/28	<b>Date:</b>	N/A

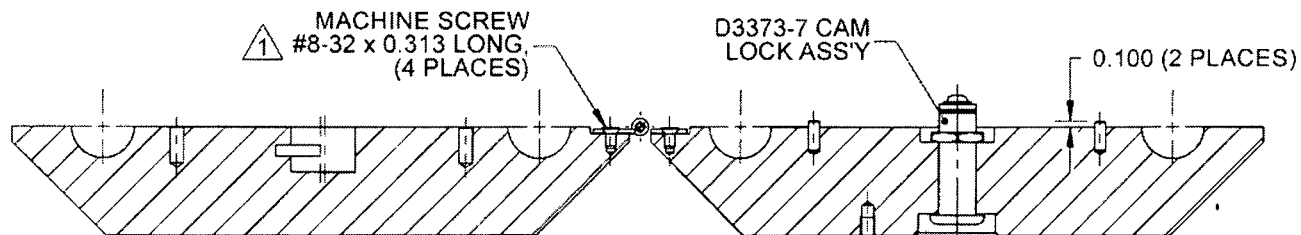
Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Dimensions and tolerances changed	KJ/JLM	
C	08.07.23	Ø0.201 & Ø0.136 dimensions removed	KJ/DD	



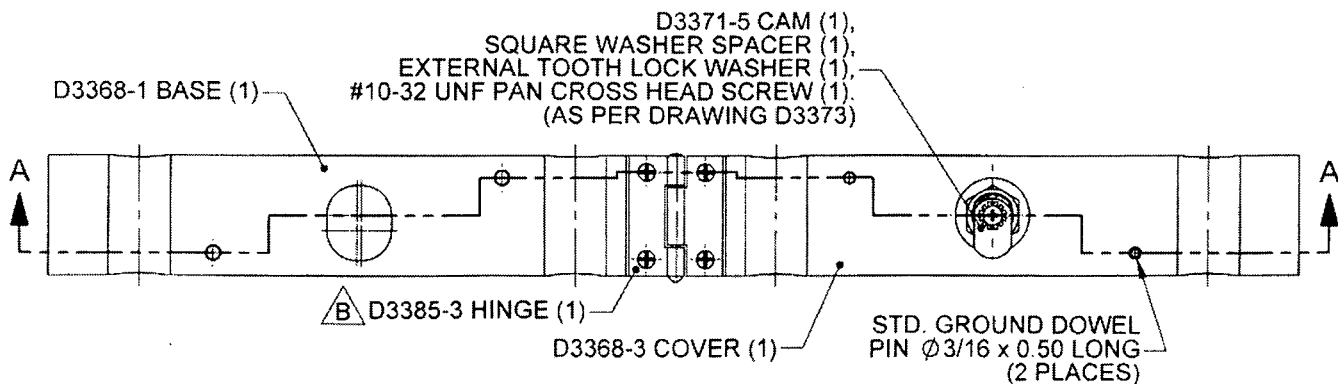
DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3368</b>	REV. B SHEET 1 OF 3
DATE	05.03.22	TITLE <b>PEDAL LOCK</b>	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



**PEDAL LOCK SHOWN LOCKED WITH KEY**



**SECTION A-A**



**D3368-051 PEDAL LOCK ASSEMBLY**

**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

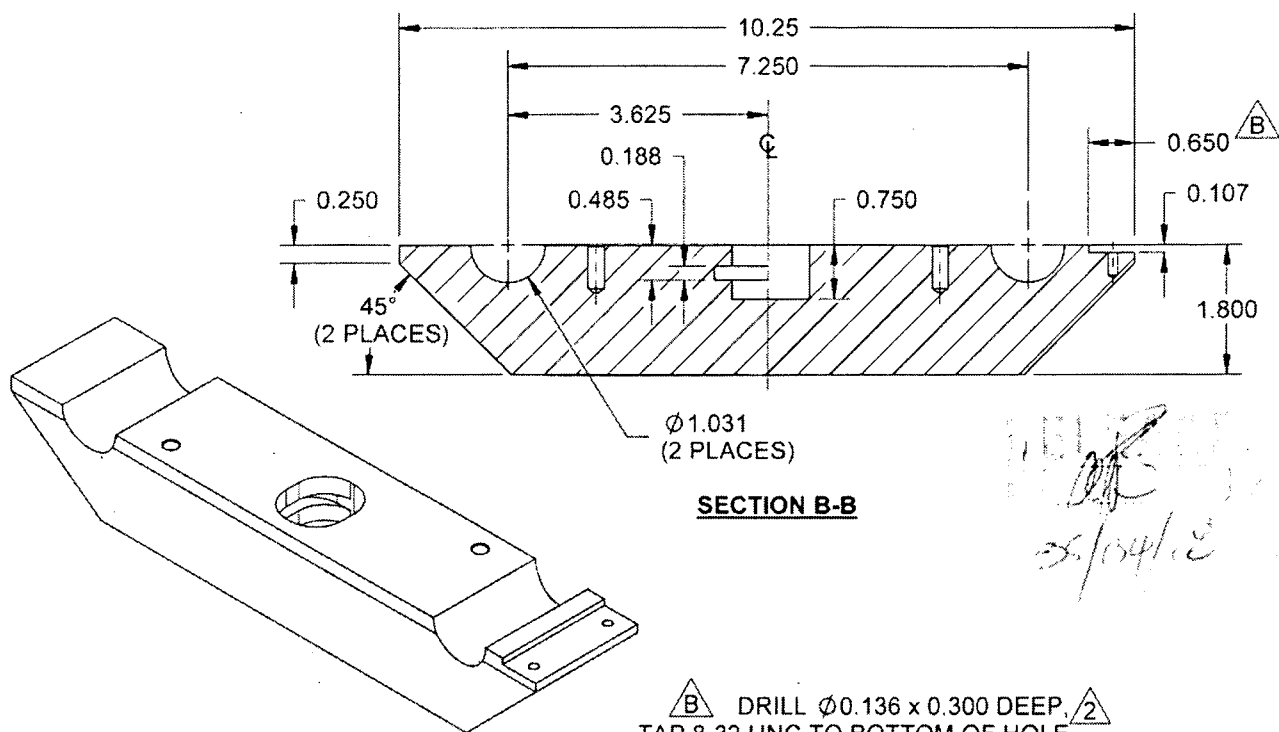
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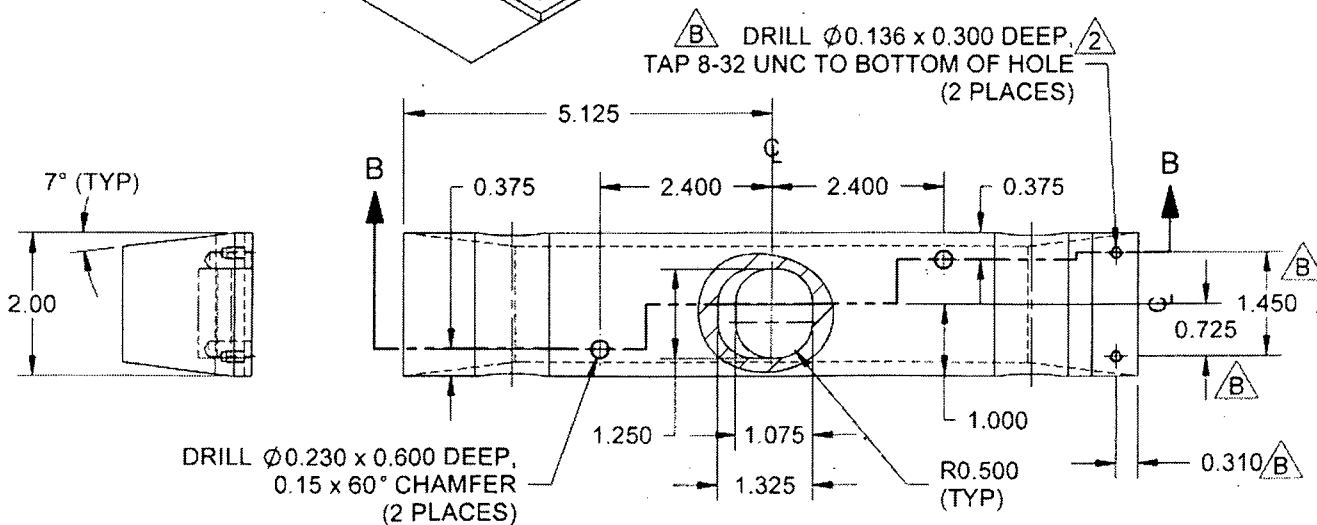
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DESIGN 13	DRAWN BY 13	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. <b>D3368</b>	REV. B SHEET 2 OF 3
DATE <b>05.03.22</b>		TITLE <b>PEDAL LOCK</b>	SCALE 1:2.5



**SECTION B-B**



**D3368-1 BASE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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